

Ship 15 Feb.

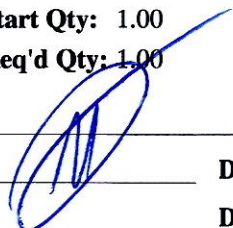
Work Order ID 156595

156595

Page 1

Thursday, February 02, 2017 9:51:57 AM

Item ID: D117-1006-012 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: BK117 Bubble Window RH
 Start Date: 2/3/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/15/2017 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan:  Date: FEB 02 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D117-1006	B								
100	Document Control								
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D117-1006-012	CHG 002							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS
6
9-89

FEB 02 2017

DAS
21
9-89

17-02-02

DAS
28
9-89

FEB 14 2017

FEB 06 2017

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

FEB 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

Work Order ID 156595***156595***

Page 2

Thursday, February 02, 2017 9:51:57 AM

Item ID: D117-1006-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: BK117 Bubble Window RH

Start Date: 2/3/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/15/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130						DAS 28 9-89	DAS 27 9-89	FEB 14 2017	
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D117-1006-012 Location: FG106								
140	QC21- Final Inspection - Work Order Release	0.00							
140							DAS 21 9-89	FFR 15 2017	
QC	Memo	0.02							
Quality Control									
							DAS 21 9-89	FEB 15 2017	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Thursday, February 02, 2017 9:52:02 AM

156595

D117-1006-012

Required Date: 2/15/2017

Required Qty: 1.00

AS PER chg003 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
LN9139M4X12		Purchased	No				Each	94.0000		2			DAS 6 9-89
I N9139M4X12 SCREW DAS 27 9-89													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST564			94			2			
					m129319		94						
D3802-1-180		Manufactured	No			110	Each	1.0000	1	1		FFR 06 2017	DAS 6 9-89
D3802-1-180 Window Seal - 180" DAS 27 9-89													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST639			1			1			
					141803		1						
D3932-1		Manufactured	No			110	Each	5.0000	2	2		FFR 06 2017	DAS 6 9-89
D3932-1 Snap Vent DAS 27 9-89													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST060			5			2			
					154893		5						
D5034-2		Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89
D5034-2 Bubble Window DAS 27 9-89													
										B156596			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

Page 2

Thursday, February 02, 2017 9:52:02 AM

Work Order ID: 156595

156595

Parent Item: D117-1006-012

D117-1006-012

Parent Item Name: BK117 Bubble Window RH

Start Date: 2/3/2017

Required Date: 2/15/2017

Start Qty: 1.00

Required Qty: 1.00

D5093-041 Manufactured No

110 Each

4.0000

1 1

D5093-041

Door Bracket Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

ST150

4

142699

4

110 Each

1.0000

1 1

D5094-041

Manufactured No

D5094-041

Post Bracket Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

ST150

1

131227

1

110 Each

9.0000

1 1

D5107-1

Manufactured No

D5107-1

Placard

DAS
28
9-89

Location

Loc Qty

Loc Code

ST152

9

138982

9

110 Each

7.0000

1 1

D5115-1

Manufactured No

D5115-1

Door Prop

DAS
28
9-89

Location

Loc Qty

Loc Code

ST366

7

121302

7

110 Each

164.0000

45 45

AN3-7A

Purchased No

AN3-7A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

ST349

164

m135058

164

Thursday, February 02, 2017 9:52:02 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Thursday, February 02, 2017 9:52:02 AM

Work Order ID: 156595

156595

Parent Item: D117-1006-012

D117-1006-012

Parent Item Name: BK117 Bubble Window RH

Start Date: 2/3/2017

Required Date: 2/15/2017

Start Qty: 1.00

Required Qty: 1.00

LN9355-6X40

Purchased

No

110

Each

40.0000

2

2

I N9355-6X40

BOLT

DAS
28
9-89

Location

Loc Qty

Loc Code

ST565

40

m129319

40

NAS1149D0363J

Purchased

No

110

Each

781.0000

90

90

NAS1149D0363.J

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

233

m134055

233

ST263

548

m136318

548

MS21042L3

Purchased

No

110

Each

1,714.000

45

45

MS21042L3

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

154

m134360

108

m135135

46

OVER007

500

M136665

500

ST303

960

M136192

7

M136406

453

M136554

500

17.02.14

27465A315

DAS
28
9-89

Qty: 1

Batch:

131711

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By _____					
				Lead hand / Supervisor Approval Verification _____					
				QC / QA Coordinator Approval _____					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

156595

Thursday, February 02, 2017 11:19:30 AM

N9000401 00

Setup Start *NS1*

Stop ***NS2***

Customer:

Run Start *NR1*

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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100	Document Control	0.00	21	Feb 02
100	DOCUMENT CONTROL		9-89	
DC	Memo	0.00		
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D117-1006-012	CHG 002		

110		
Packaging	Memo	0.00

120			
QC	Memo		0.01

Quality Control

4.0 WEIGHT AND BALANCE

The following is the weight of the D117-1006-012 Bubble Window kit. It is the responsibility of the installer to account for the weight and balance of all removed parts.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-1006-012 Bubble Window Kit	6.89 lb 2.1 kg	44.8 in 1.1 m	308 in-lb 2.3 m-kg	112.9 in 2.9 m	778 in-lb 6.1 m-kg

5.0 PARTS LIST

Qty -012	Part Number	Description
X	D117-1006-012	BUBBLE WINDOW KIT
1	D3802-1-180	SEAL
2	D3932-1	SNAP VENT
1	D5034-2	BUBBLE WINDOW
1	D5093-041	DOOR BRACKET ASSY
1	D5094-041	POST BRACKET ASSY
1	D5107-1	PLACARD
1	D5115-1	DOOR PROP
45	AN3-7A	BOLT
2	LN9139-0412	SCREW
2	LN9355 6X40	BOLT
90	NAS1149D0363J	WASHER (AN960JD10)
45	MS21042L3	NUT
1	27465A315	DRILL BIT FOR PLASTICS

m131711